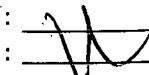

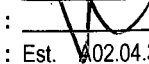


Date: Monday, 1/14/2008 1:14:42 PM
 User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 36761	
Estimate Number : 11470	
P.O. Number : N/A	Part Number : D314099
This Issue : 1/14/2008 S.O. No. : N/A	Drawing Number : D3140 REV F
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : F
Previous Run : 35156	Material : N/A
	Due Date : 1/16/2008
Written By : 	Qty:  Um: Each
Checked & Approved By : 	
Comment : Est. 02.04.30 New Issue NG Est. Rev B New dwg rev. ecn781 06.04.18 EC Est. rev.C added scuffing NCR 061 EC Est Rev:D As per ECN #829 06-11-20 JLM Est Rev:E Now On Waterjet 07-03-28 JLM	

Additional Product

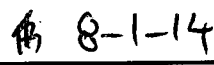
Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S032	2024-T3 .032 sheet
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Comment: Qty.: 0.1422 sf(s)/Unit Total : 0.2843 sf(s)
 2024-T3 .032 sheet
 Mat: 2024-T3 (QQ-A-250/4) .032" thick
 (M2024T3S.032) Batch 18147 

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3140
 Dwg Rev: F
 Prog Rev: F

 18 8-1-14 

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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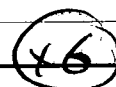


Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

 08/01/14 

Date: Monday, 1/14/2008 1:14:42 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 36761

Part Number: D314099

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Scuff surfaces with 80grit sandpaper per QSI 006

2-Deburr.

No sharp edges

CP 08/01/15 (6)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BF 08-01-16 (6)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 08/01/16 (6X)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 142*

CP 08/01/16 (6)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/01/17 (6)
08/01/17
u

Job Completion



